

Date: Wednesday, 29/04/2009 8:27:59 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FUEL PURGE CANISTER  
 Job Number : 47499  
 Estimate Number : 10440  
 P.O. Number :  
 This Issue : 29/04/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 27/04/2009 Type : LARGE FAB ASSY  
 Previous Run : 46642  
 Part Number : D3262041  
 Drawing Number : D3262 REV C  
 Project Number : N/A  
 Drawing Revision : C  
 Material :  
 Due Date : 12/05/2009 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est. C 05.03.10 Removed P/O for liquid penetrant inspection K  
 J/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D32621 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Tube B 46642 4PC BE 09/05/05

2.0 D32623 Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Cap B 45929 6PC B 41823 2PC BE 09/05/05

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
 Weld canister assembly as per Dwg D3262 using DT8739 to align fillings  
 Pick: Qty Part Number Description Batch  
 A/R Aluminum Rod M110972 BE 09/05/05

4.0 QC9 VISUAL WELDING INSPECTION



Comment: WELD INSPECTION  
 Pressure test as per Dwg D3262

PD 09.06.09 (3)

5.0 QC5 INSPECT WORK TO CURRENT STEP

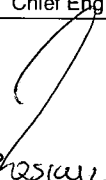
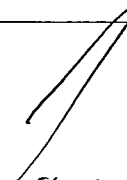






Comment: INSPECT WORK TO CURRENT STEP

S 09/06/10 (X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3262-041 PAR #: N/A Fault Category: Prod / Inv. LG NCR: (Yes) No DQA: DA Date: 09/06/10  
 Resolution: D412-706-0119 13/015 ~~Process~~ Scrap Disposition: Scrap QA: N/C Closed: DA Date: 09/06/10

NCR: <u>47499</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/5/6	# 4.0	During welding Pressure lost Qty 2 canisters <del>both</del> were found with numerous air leaks around the weld. After re welding still		Identify the affected area's. ground at the weld & re-weld per Q51004. AR <u>1111679</u>	<u>BE</u> <u>09/06/09</u>	<u>S</u> <u>09/06/10</u>		<u>S</u> <u>09/05/06</u>
		leaked. R.C. welder noticed at welding the caps "were loose fitting" AND parts have contamination at Process				<u>S</u> <u>09/06/10</u>		<u>S</u> <u>09/05/06</u>
9/5/6	# 4.0	1 cap stripes <del>when</del> when installing the air hose and plugs R.C. threads were faulty.		Scrap & destroy Qty 1	<u>BE</u> <u>09/06/09</u>	<u>S</u> <u>09/06/10</u>		<u>S</u> <u>09/05/06</u>

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 8:27:59 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 47499

Part Number: D3262041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 09-06-10 (3)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

✓ 1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

✓ 2-Ensure to mask threads

START TIME:

11:15 AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

11:45 AM

BR 09-06-11

(X3)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-06-11

(3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location:

177

91411

SR

(31)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/12

Job Completion

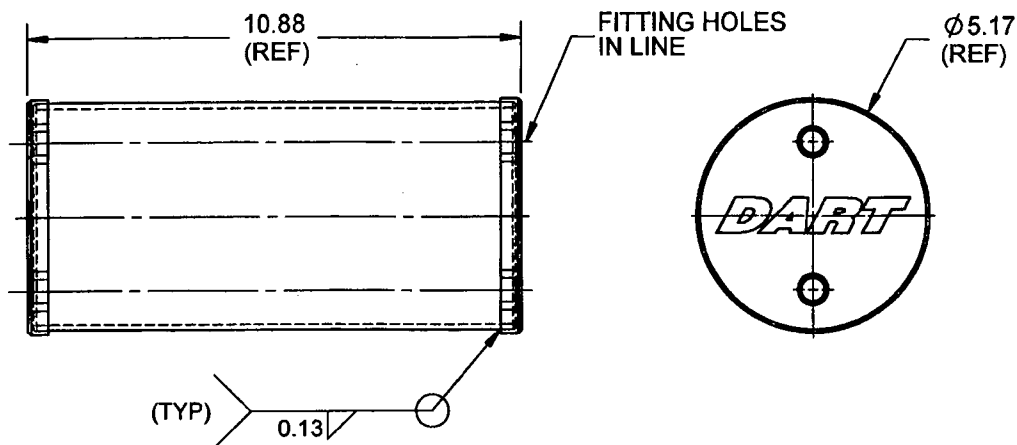


MF 09-06-12

**DART**

DESIGN <i>RH</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3262</b>	REV. C SHEET 1 OF 2
DATE <b>06.08.31</b>		TITLE <b>FUEL PURGE CANISTER</b>	SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.05.06	FIRST ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	
C	06.08.31	Ø 5.165 WAS Ø 5.190	

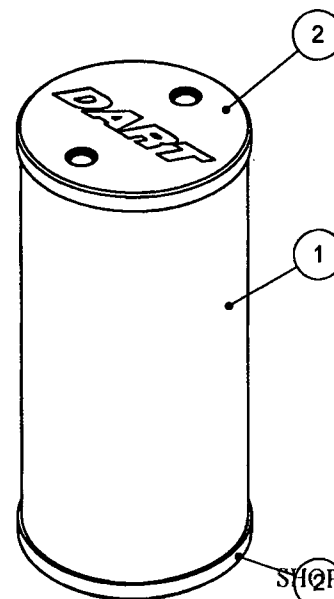
RELEASED

06.09.19 *H***D3262-041 CANISTER ASSEMBLY**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3362-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS **B**
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER

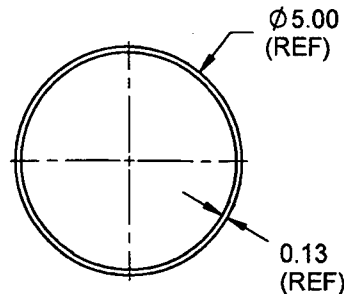
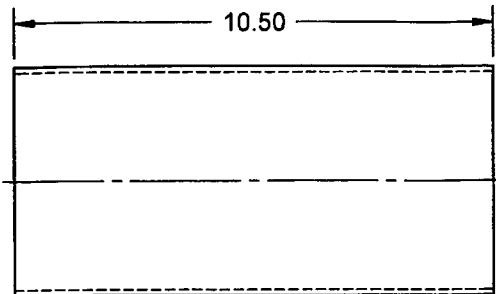
SHIP COPY  
RETURN TO  
ENGINEERINGUNCONTROLLED COPY  
SUBJECT TO AMENDMENTWITHOUT NOTICE  
WORK ORDERNO. *47499*

COPYRIGHT © 2004 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

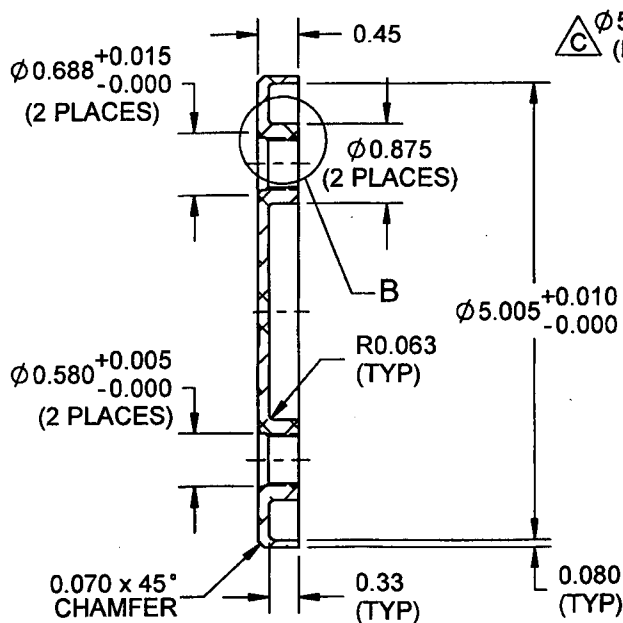
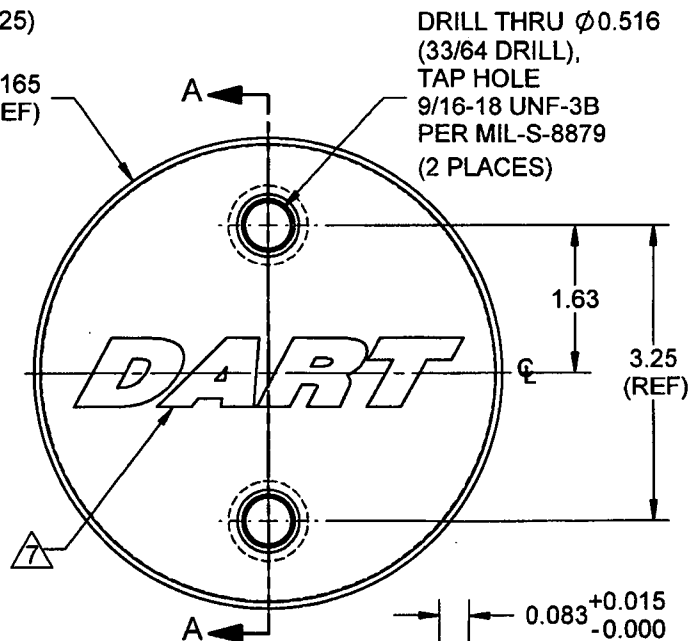
DESIGN <i>PH</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. <b>D3262</b>	REV. C SHEET 2 OF 2
DATE <b>06.08.31</b>		TITLE <b>FUEL PURGE CANISTER</b>	SCALE 1:4

**RELEASED**

06.09.11

**D3262-1 TUBE**

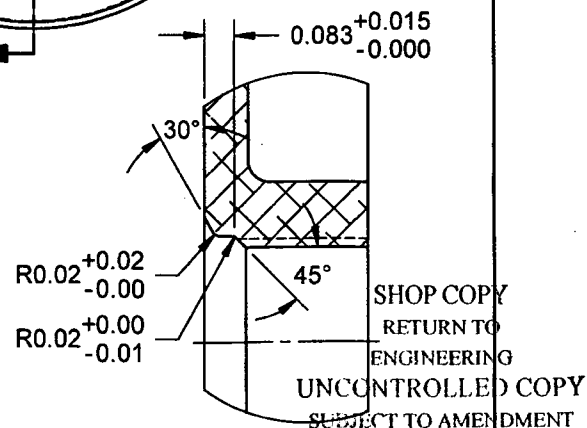
- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR  
QQ-A-200/8 OR QQ-A-225/8  
(REF. DART SPEC. M6061T6T5.000W.125)

**SECTION A-A**  
SCALE 1:2**D3262-3 CAP**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR  
(REF. DART SPEC. M6061T6B)

**NOTES:**

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)

**DETAIL B**  
SCALE 2:1

NO. 4249

COPYRIGHT © 2004 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.